

Date: Monday, 18/08/2008 10:22:40 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FWD TUBE ASSEMBLY
<b>Job Number</b> : 41276	
<b>Estimate Number</b> : 10467	
<b>P.O. Number</b> :	<b>Part Number</b> : D3391021
<b>This Issue</b> : 18/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3391 REV G
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : G
<b>Previous Run</b> : 41275	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/09/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.8.18</u>	
<b>Comment</b> : Est. A 05.09.13 New issue KJ/JLM Est. B 06.02.10 Dwg rev.D ecn 773 EC Est. C 06.05.02 Added inspections EC est D 07.03.13 rev F dwg EC est E 07.11.07 revG dwg ecn1053P EC verified by: DD Est Rev:f ECN 1056 07-11-12 DD verified by: EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6013047

Skidtube Material



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description
1	D6013-047	Extrusion

Batch

B-26547

AWM

8-8-18

2.0

SKIDTUBES 1

SKIDTUBES RESOURCE 1



**Comment:** LANDING GEAR RESOURCE 1  
 Cut extrusion to 46.52 +0.010 -0.020

AWM 8-8-18

3.0

BENDING

BENDING MACHINE - SKIDTUBES



**Comment:** No bender  
 Bend as per Dwg D3391 Using Bend Prog 3391021

2T 08-08-19

4.0

QC5

INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT WORK TO CURRENT STEP

DP 8-8-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



90

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. \_\_\_\_ & Dwg D3391 Rev. \_\_\_\_

Identify as D3391-1

2-Deburr

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391


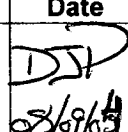
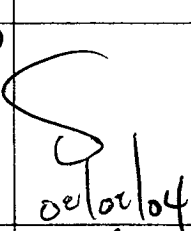

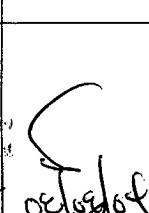

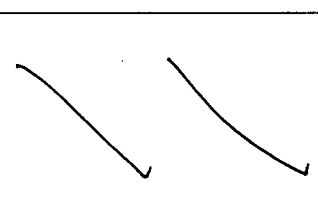
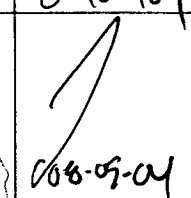

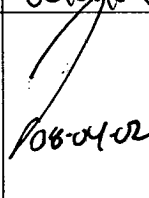
5-Deburr & Scribe Batch number Inside aft end.

6-Transfer drill D3391-021 with D3391-023

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/04	#5.0	Pant scraped due to the 0.687" cut out for the inner moving ridge is off. Tube was tested in mid tube and		SCRAP and destroy no replace Qty (40)	 8/9/04	 08/09/04	 08/09/04	 08/09/04
		work <del>side</del> SLIDE in. P.C. operator on other shift put wrong angle plate on setup > LACK of				 08-09-04	 08/09/04	 08-09-04
		Attention.						

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0	D36704200	SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: \_\_\_\_\_

15.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: \_\_\_\_\_

exp. date: \_\_\_\_\_

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

17.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME: \_\_\_\_\_

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0

ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
INSERT  
batch: \_\_\_\_\_  
or equivalent  
per QSI 017

20.0

ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
INSERT  
batch: \_\_\_\_\_  
or equivalent  
per QSI 017

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Install Inserts as per Dwg

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Tow Cap Assembly  
Pick:  
Qty Part Number Description Batch  
1 D3401-041 Tow Cap \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NQN-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

25.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET

26.0

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
PHENOLIC WASHER

27.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Bolt  
Pick:  
Qty Part Number Description Batch  
4 AN3C4A Bolt

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
washer

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Install tow Cap as per Dwg D3391  
Identify as D3391-021

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inspect thread of each insert using DT8821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 88-09-05

*Scrap*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

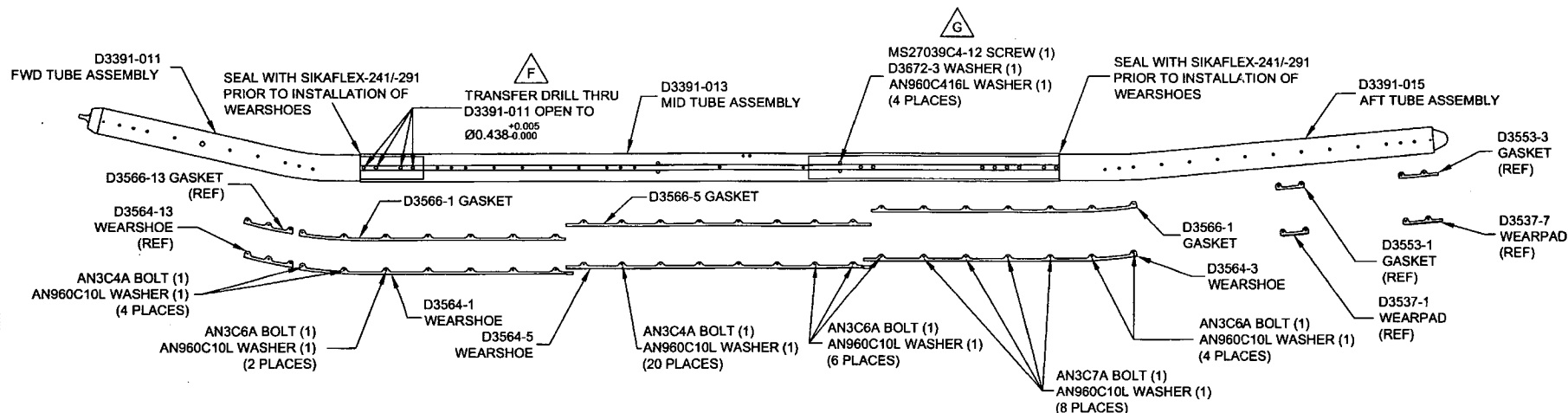
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





**D3391-041 ASSEMBLY**

**RELEASED**  
07-11-06

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3572-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
3	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

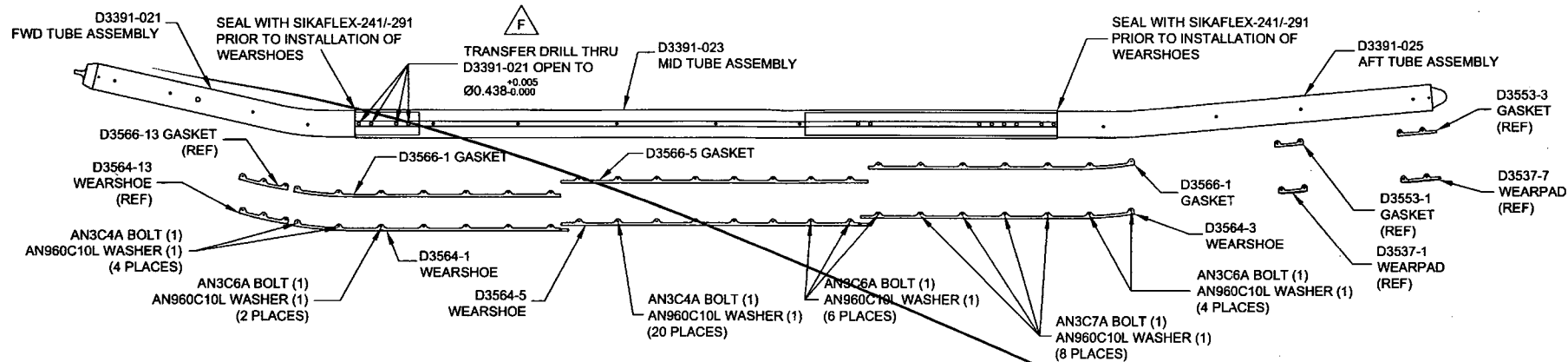
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3391  
REV. G  
SHEET 1 OF 8  
TITLE 412 FLOAT SKIDTUBE  
SCALE NTS

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**D3391-043 ASSEMBLY**

**RELEASED**  
07.11.91

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER

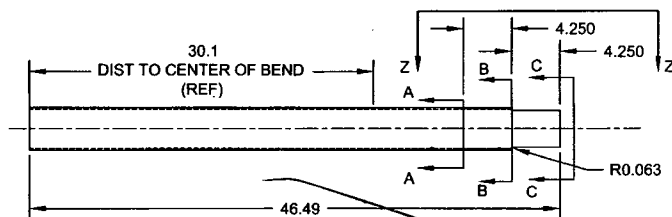
**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL  $\varnothing 0.297$  SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

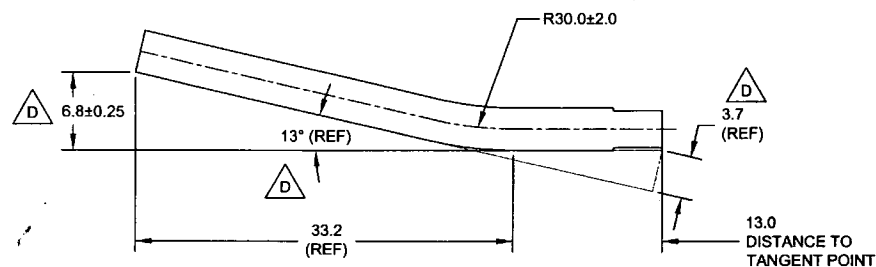
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CHECKED	MFG. APPR.	DRAWING NO.	REV. G
APPROVED	DE APPR.	D3391	SHEET 2 OF 8
DATE		TITLE	
07.07.31		412 FLOAT SKIDTUBE	
		NTS	

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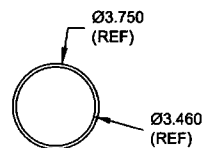
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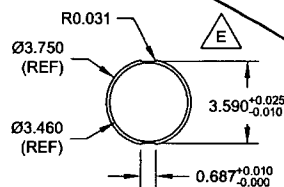
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



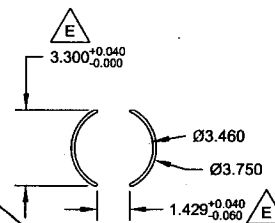
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



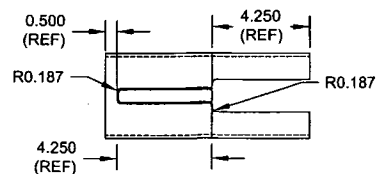
**SECTION A-A**  
(SCALE 1:5)



**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



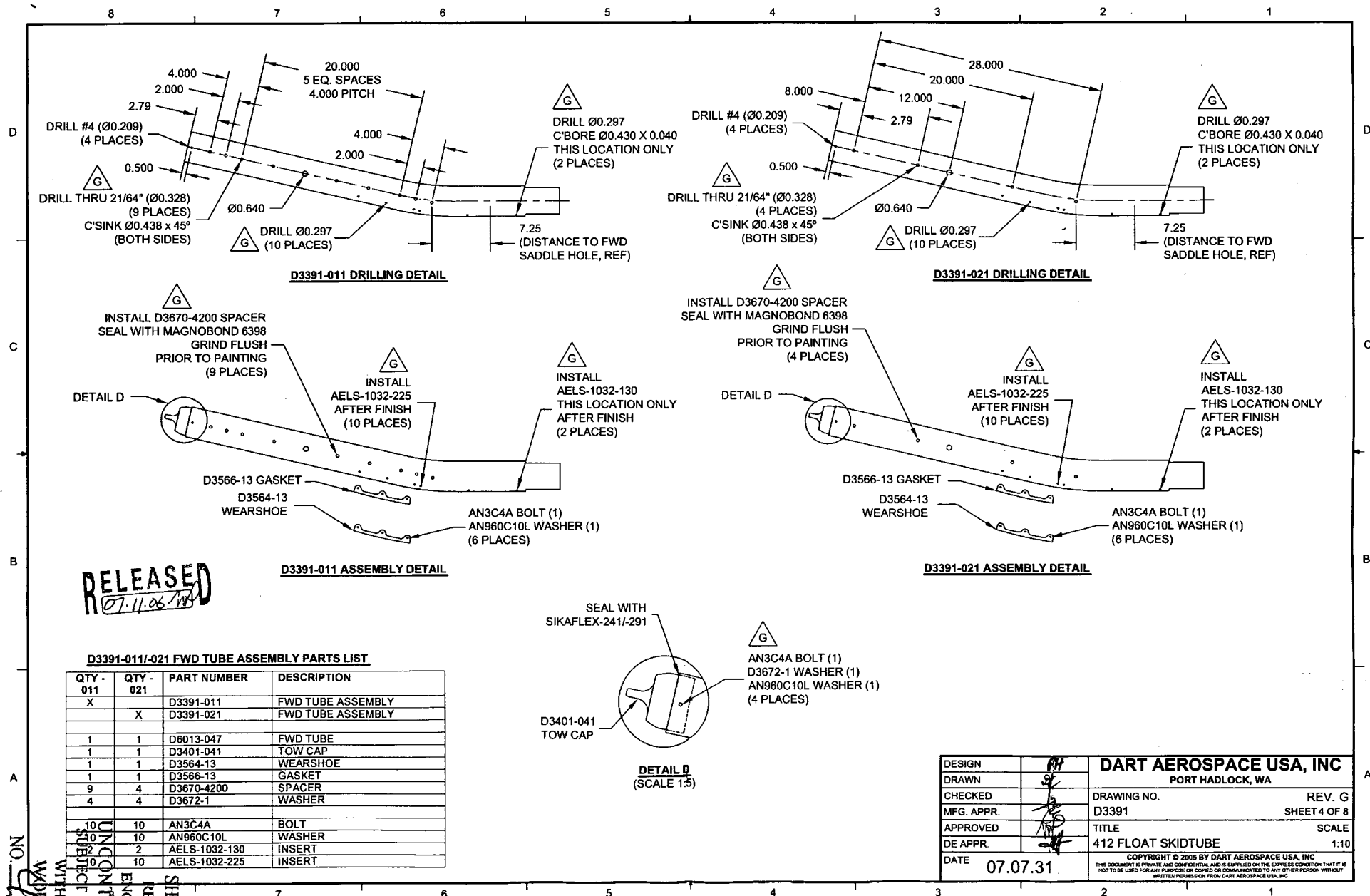
**VIEW Z-Z**  
(SCALE 1:5)

RELEASED  
07-11-06 11P

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DRAWN	SH	PORT HADLOCK, WA	
CHECKED	SH	DRAWING NO.	REV. G
MFG. APPR.	SH	D3391	SHEET 3 OF 8
APPROVED	SH	TITLE	SCALE
DE APPR.	SH	412 FLOAT SKIDTUBE	1:10
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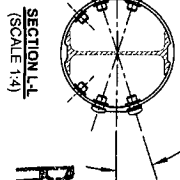
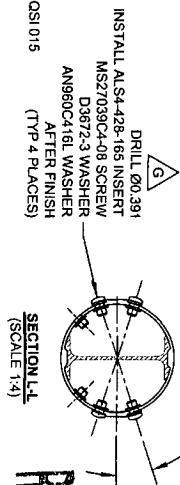




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QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
12	D3881-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	ALS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN980C10L	WASHER
4	AN980C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

UNCLASSIFIED  
MATERIAL: MAKE FROM D2500-1-100 EXTRUSION  
INSTALL D3391-013 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER CSI 015

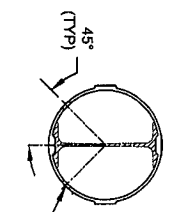


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07.11.2016

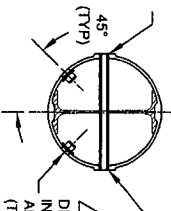
DESIGN	#	TITLE	REV / G
DRAWN	DP	DRAWING NO.	D3391
CHECKED			
APPROVED			
DATE	07.07.31	412 FLOAT SKIDTUBE	SCALE 1:20

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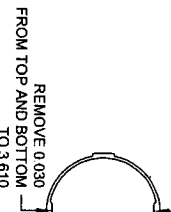
SECTION G-G  
(SCALE 1:4)



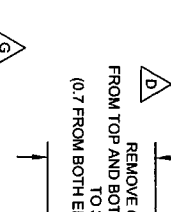
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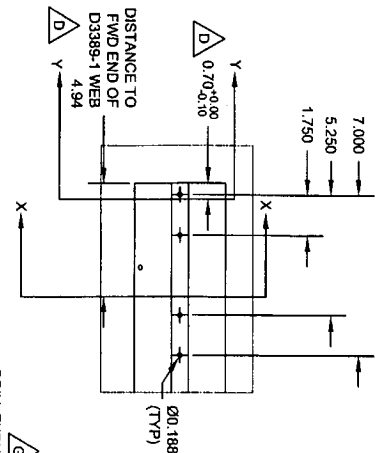
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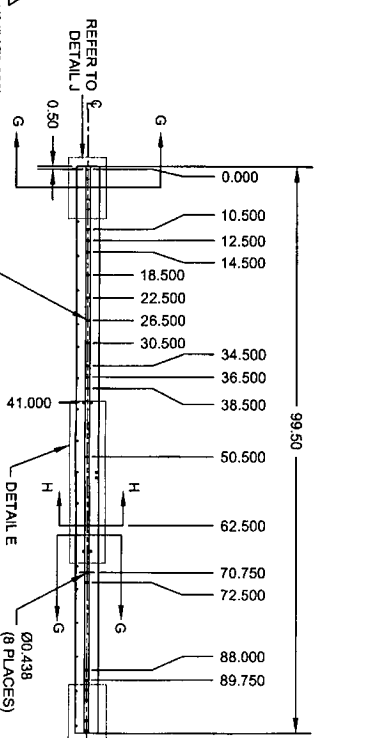
SECTION Y-Y  
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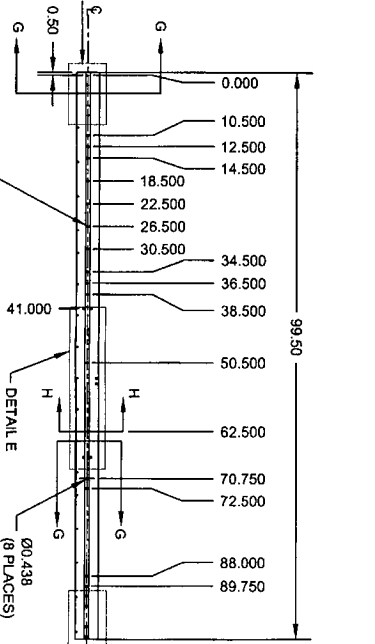
DETAIL J  
(SCALE 1:5)



DETAIL K  
(SCALE 1:5)

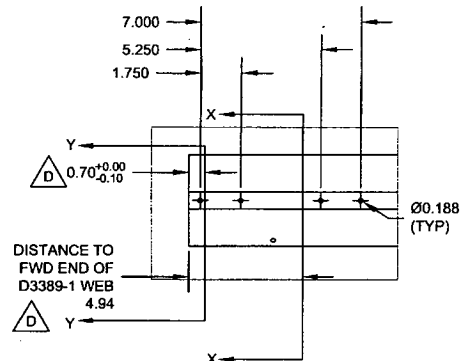


D3391-013 ASSEMBLY DETAIL

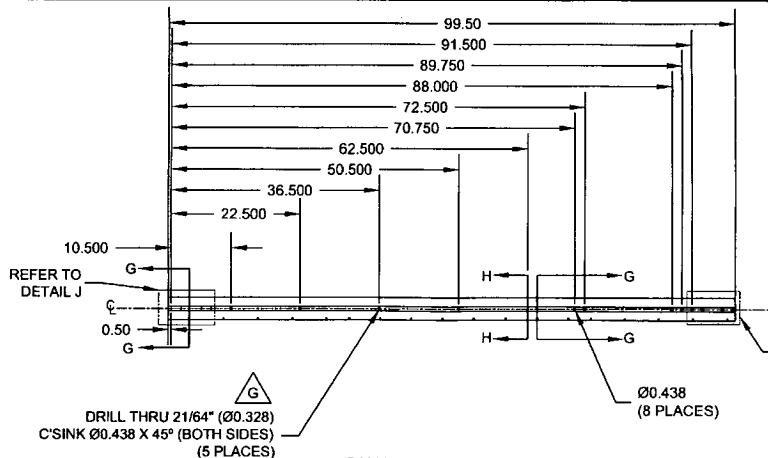


8 7 6 5 4 3 2 1

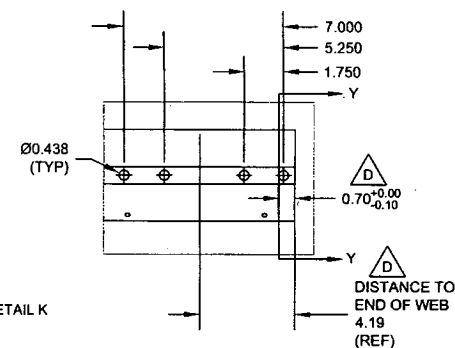
D



**DETAIL J**  
(SCALE 1:5)

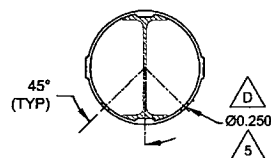


**D3391-023 ASSEMBLY DETAIL**

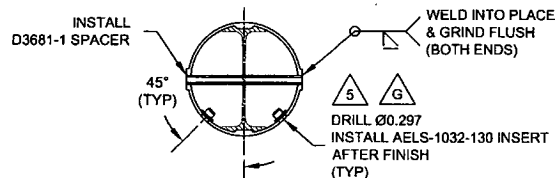


**DETAIL K**  
(SCALE 1:5)

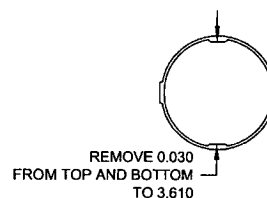
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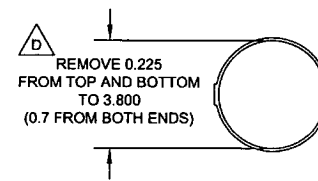
**SECTION G-G**  
(SCALE 1:4)



**SECTION H-H**  
(SCALE 1:4)



**SECTION X-X**  
(SCALE 1:4)



**SECTION Y-Y**  
(SCALE 1:4)

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

RELEASED  
07-11-06/11

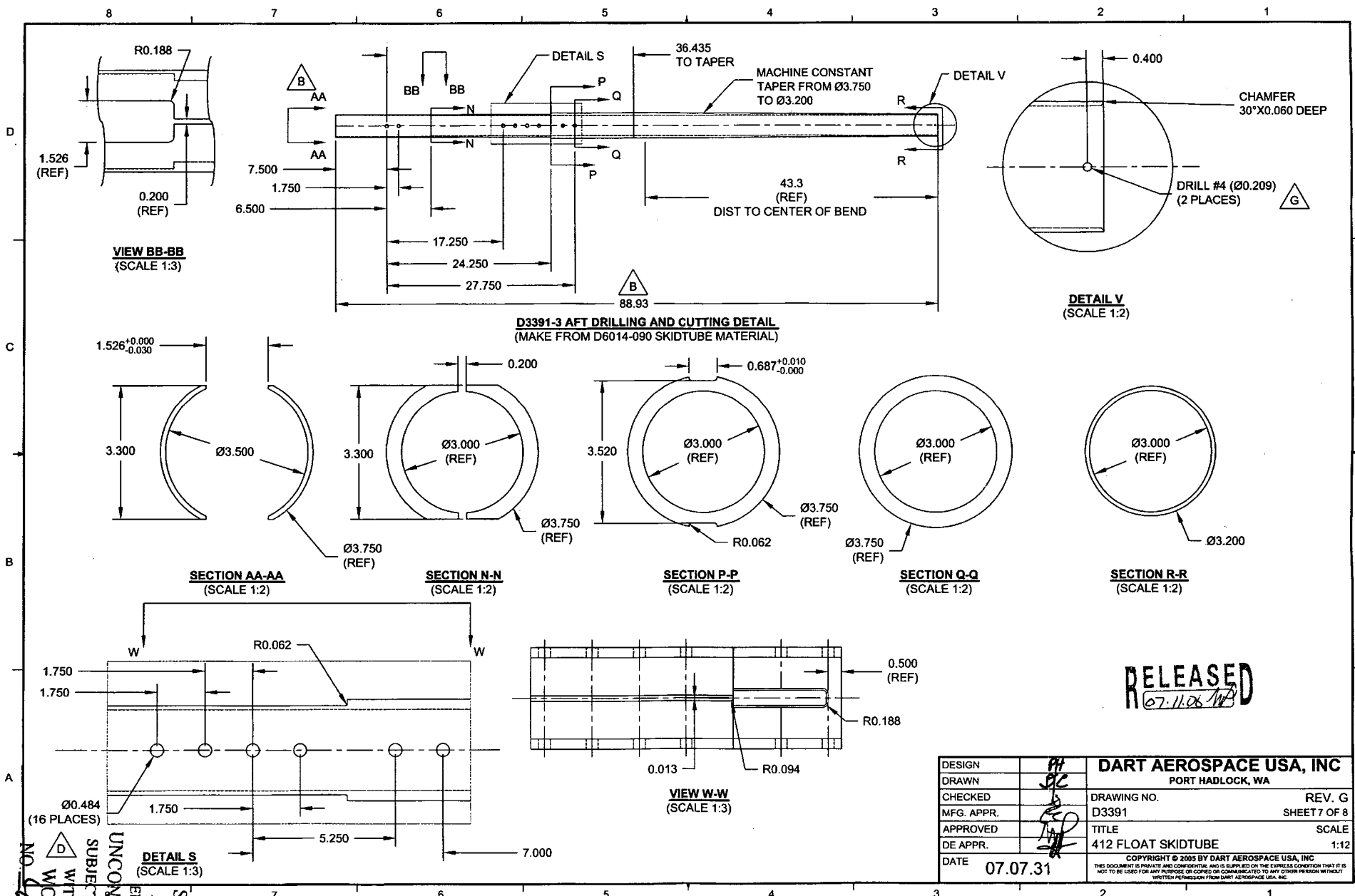
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	DE	PORT HADLOCK, WA
CHECKED	5	DRAWING NO. D3391
MFG. APPR.	RD	REV. G
APPROVED	RD	SHEET 6 OF 8
DE APPR.	RD	TITLE 412 FLOAT SKIDTUBE
DATE	07.07.31	SCALE 1:20

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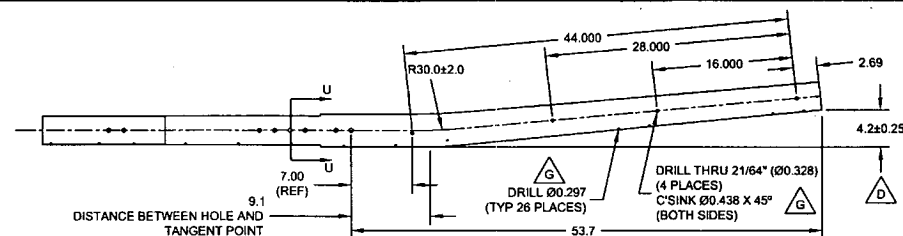
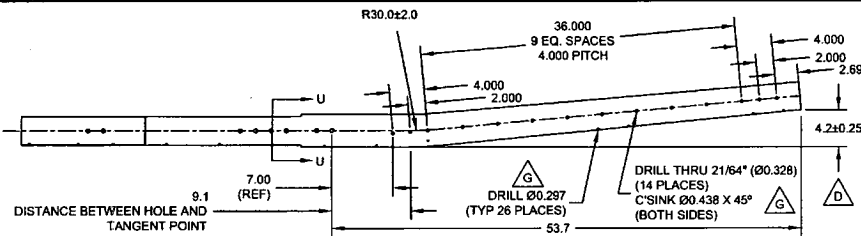
WORK ORDER  
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D3391-023 MID TUBE ASSEMBLY  
MATERIAL: MAKE FROM D2500-1-100 EXTRUSION  
INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015  
WELDING PER DART QSI 004

7 6 5 4 3 2 1



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**D3391-015 BENDING AND DRILLING DETAIL**  
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
(14 PLACES)

**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
(4 PLACES)

**D3391-015 ASSEMBLY AND C'BORE DETAIL**  
(SEE TABLE)

AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
(4 PLACES)

AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(4 PLACES)

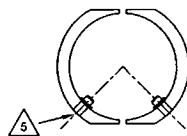
**D3391-025 ASSEMBLY AND C'BORE DETAIL**  
(SEE TABLE)

AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
(4 PLACES)

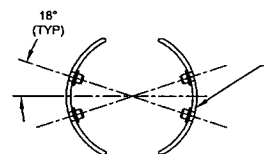
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(4 PLACES)

**D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-3	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

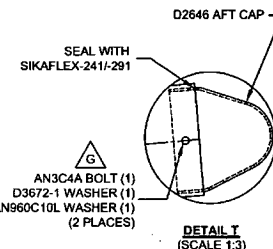


**SECTION U-U**  
(SCALE 1:3)



**SECTION CC-CC**  
(SCALE 1:3)

DRILL Ø0.391  
C'BORE Ø0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT (1)  
(4 PLACES)



**RELEASED**  
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	DK	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. G
MFG. APPR.		D3391 SHEET 8 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE 1:12
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